

Work Order ID 51340

August 19, 2009 11:36:17 AM



Page 1

Item ID:	D3826-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Rib / Gusset Assembly					
Start Date:	08/19/2009	Start Qty:	6.00		Cust Item ID:	
Required Date:	08/25/2009	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>09-08-19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3826	Rev B								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod Batch: <u>M109213</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

SP 09 08 25

DD 09 08 26

278 09/09/26

QC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3826-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rib / Gusset Assembly

Start Date: 08/19/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 08/25/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *Basket*

0.00



Packaging

Memo

0.00

Packaging

PD 09.08.26

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/08/27**PD 09-8-26*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 51340

Parent Item: D3826-041RevB

Parent Item Name: Rib / Gusset Assembly

Start Date: 08/19/2009

Required Date: 08/25/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2235-1RevB1

Manufactured

No

Each

7.0000

6.0000



Basket Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

50565

50822

B51252

7

3

4

Each

11.0000

6.0000

3x

3x

SY 09/08/20

D3929-041RevA

Manufactured

No



Gusset Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47273

50870

51170

11

1

4

6

Each

14.0000

6.0000

4x

2x

SY 09/08/20

D3929-042RevA

Manufactured

No



Gusset Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50567

51137

50869

14

5

9

3x

2x

1x

SY 09/08/20

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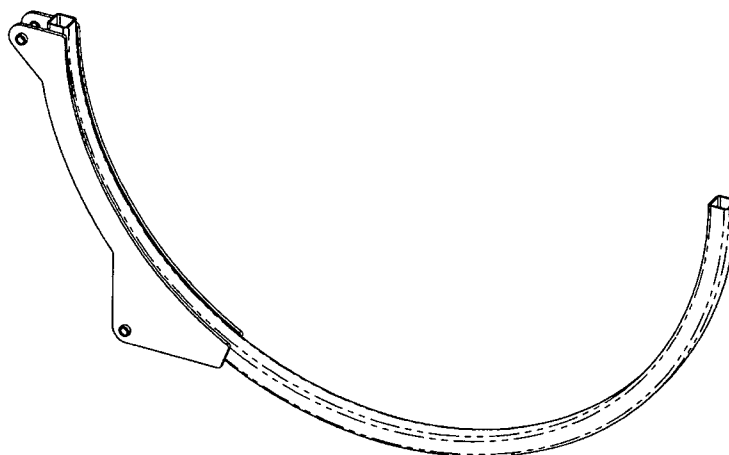
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ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51346

mf
09-08-19



D3826-041 RIB/GUSSET ASSY

RELEASED
09/04/16

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.32 lbs

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	16	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	15	DRAWING NO.	REV. B
CHECKED	14	D3826	SHEET 1 OF 2
MFG. APPR.	13	TITLE	SCALE
APPROVED	12	RIB/GUSSET ASSY	NTS
DE APPR.	11	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	09.04.16		

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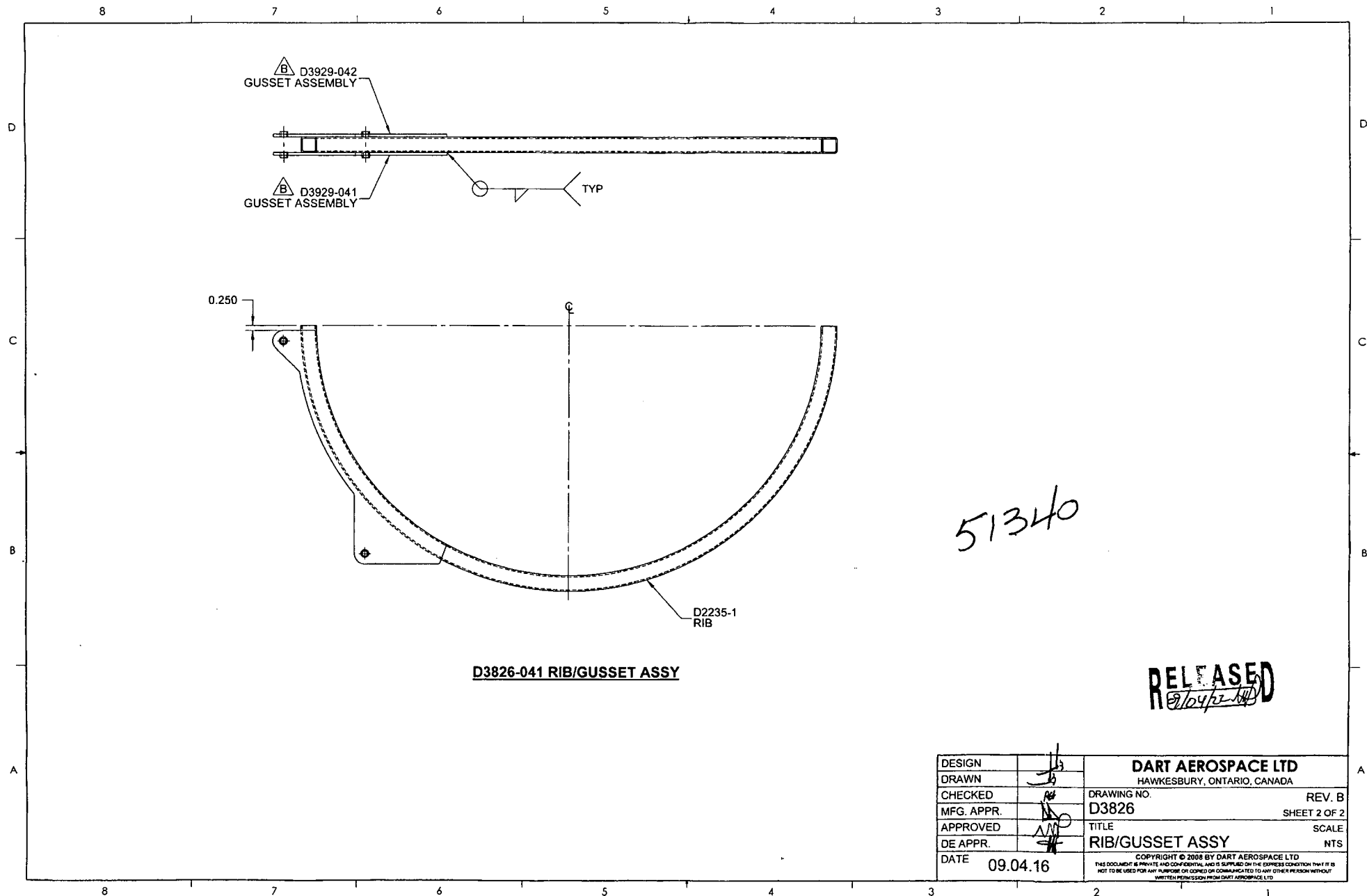
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